

Date: Tuesday, 08/04/2008 12:51:00 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STRUT
Job Number : 38454	
Estimate Number : 10220	
P.O. Number :	Part Number : D219925
This Issue : 08/04/2008 S.O. No. :	Drawing Number : D2199 / D2638
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : E1/ A
Previous Run : 37537	Material :
Written By :	Due Date : 14/04/2008 Qty: 6 Um: Each
Checked & Approved By : <u>JD 08.4.08.</u>	
Comment : Est:D 02.06.10 Rmv polish & add finish NG/RF	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0750W049	304 RD Tube .750 x .049W
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**Comment:** Qty.: 1.7675 f(s)/Unit Total : 10.6048 f(s)

Material: 304/316 SS tubing 0.750" Dia. x 0.049" wall

(M304TR0750W049)

Batch No: M107518SB 08/04/09

2.0	BRAKE NC	NC BRAKE
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**Comment:** BRAKE NC

Punch per Dwg D2199 and Spec Control Dwg D2638

SB 08/04/09

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

Deburr

SB 08/04/09

4.0	QC5	INSPECT WORK TO CURRENT STEP
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**Comment:** INSPECT WORK TO CURRENT STEPSB 08/04/10

5.0	POWDER COATING	POWDER COATING
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**Comment:** POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

M107550M-L 08/04/10

6.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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**Comment:** INSPECT POWDER COATSB FA 08/04/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 08/04/2008 12:51:00 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 38454

Part Number: D219925

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 264

AS 08/04/11

(x6)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



08/04/15

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



m f 08-04-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

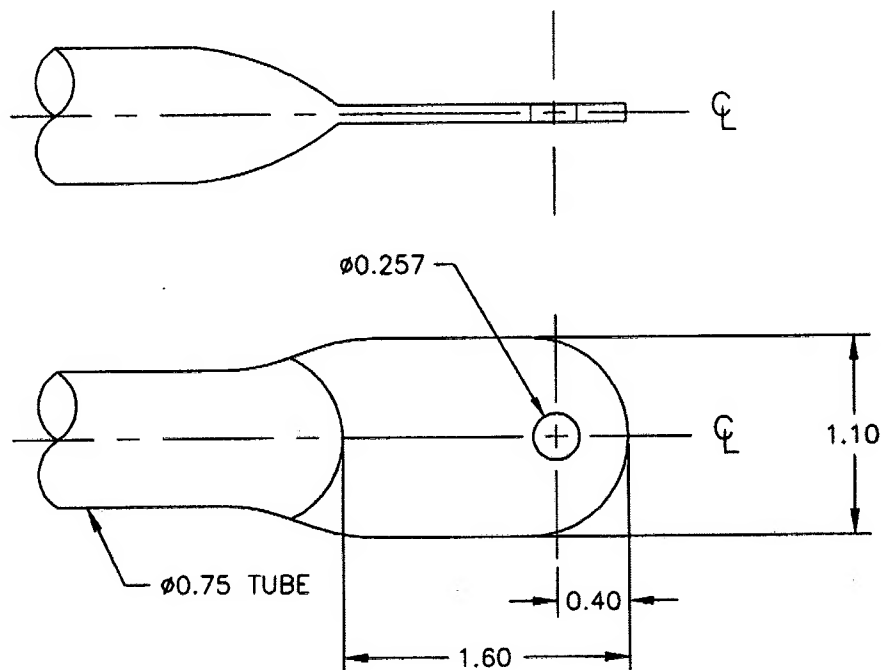
NOTE: Date & initial all entries





DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED ME	APPROVED KE	DRAWING NO. D2638	REV. A SHEET 1 OF 1
DATE 98.04.28		TITLE PUNCH DT8117 SPEC CONTROL	SCALE 1:1
A	98.04.28	NEW ISSUE	

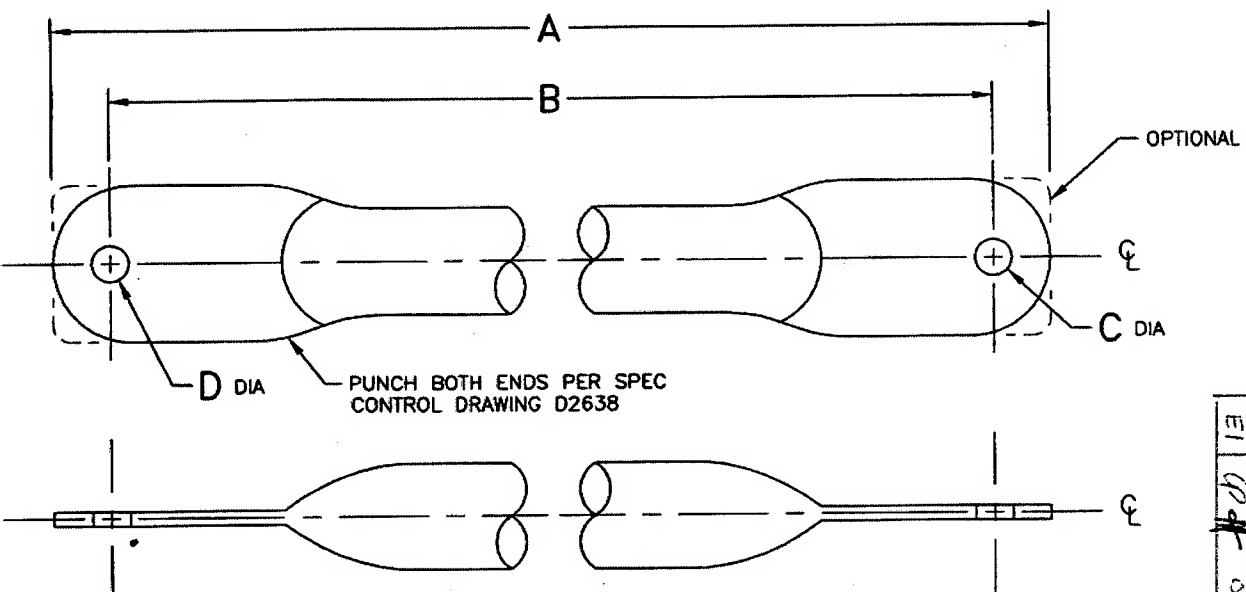
RELEASED
4/5/05 KE

SPECIFICATION CONTROL DRAWING
FOR PUNCH DT8117



SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38454

DESIGN		DRAWN BY		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 		APPROVED 		REV. E SHEET 1 OF 1	
DATE		D2199		SCALE	
98.04.28		TITLE		STRUT DETAILS	
A	1993	NEW ISSUE			
B		ADDED -11, -13, AND -15			
C		ADDED -17 AND -19			
D		ADDED -21			
E	98.04.28	ADDED -23 AND -25 PER TSR A565M ADDED TEMPLATE & SPEC CTRL DWG REDRAWN IN CAD			
E1	98.04.28	ADD FINISH			



	A	B	C	D
D2199-1	18.30	17.50	0.257	0.257
D2199-3	5.80	5.00	0.257	0.257
D2199-5	22.64	21.84	0.257	0.316
D2199-7	14.74	13.94	0.257	0.257
D2199-9	16.52	15.72	0.257	0.257
D2199-11	23.60	22.80	0.257	0.316
D2199-13	15.96	15.16	0.257	0.257
D2199-15	17.57	16.77	0.257	0.257
D2199-17	28.05	27.25	0.257	0.316
D2199-19	18.90	18.10	0.257	0.257
D2199-21	10.80	10.00	0.257	0.257
D2199-23	26.18	25.38	0.257	0.316
D2199-25	19.93	19.13	0.257	0.257
D2199-27	27.34	26.54	0.257	0.316
D2199-29	21.11	20.31	0.257	0.257

B
B
B
C
C
D
E
E

* 00.10.13
(P 00.10.13)

NOTES:

1. MAKE PER TEMPLATE DT2199-XX WHERE XX IS THE RESPECTIVE DASH NUMBER
2. MATERIAL: AISI 304/316 STAINLESS STEEL TUBE 0.750 x 0.049 WALL
3. FINISH: POWDER COAT WHITE (4.3.5.2) PER PART QSI 005 4.3 